

Ship Sept 24/15

Work Order ID 136062

136062

Page 1

Item ID: D205-523-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/17/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: 41 Date: 20150827

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI9301	Rev A

DAS
6
9-89

100 Document Control 0.00
DOCUMENT CONTROL

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy blue file & type labels as per PPP D205-523-013, CHG 002

(4)

DAS
38
9-89

MLG 1509-03

SEP 08 2015

110 Pick Kit 0.00

110

Packaging

Memo

0.00

Packaging

SEP 03 2015

27
9-89

120 QC4- 100% Inspect kits for completeness 0.00

120

QC

Memo

0.00

Quality Control

(4)

DAS
38
9-89

SEP 08 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

Work Order ID 136062

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136062

Page 2

Item ID: D205-523-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/17/2015 Req'd Qty: 4.00

4

Customer:

Reference:

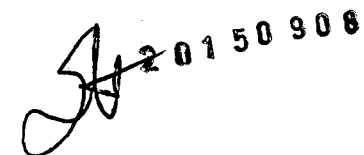
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130						DAS			
Packaging	Memo	0.00				6			
Packaging	Package as per PPP D205-523-013	Identify and Stock				989			SEP 08 2015
	Location : FG018								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01							
Quality Control									

20150908

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 136062

136062

Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015

Required Date: 9/17/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B02.04.04 Updated Drawing and Added Inspection Level 21SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D205-523-043 *D205-523-043* Slide Bar Assembly		Manufactured DAS 38 9-89	No			110	Each	2.0000	1	4	DAS 6 9-89	27 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST374				2		B136062	3		
				114929				2		B136108	1		
D2224 *D2224* Rappel Anchor Assembly		Manufactured DAS 38 9-89	No			110	Each	13.0000	1	4		27 9-89	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST479				13					
				114998				1					
				123383				6					
				123801				1					
				126418				5					
D2229 *D2229* Doubler		Manufactured DAS 38 9-89	No			110	Each	20.0000	2	8			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST004				20					
				110094				2					
				112921				18					

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Work Order ID: 136062

136062

Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015

Required Date: 9/17/2015

Start Qty: 4.00

Required Qty: 4.00

AN5-14A

DAS
38
9-89

Purchased

No

110

Each

57.0000

4

16

AN5-14A

Bolt

**

68-6
9
DAS
27
9-89

Location

Loc Qty

Loc Code

ST299A

25

m132763

25

ST338

32

m131957

7

m132823

25

MS21042L5

Purchased

No

110

Each

543.0000

4

16

MS21042L5

Nut

DAS
38
9-89

**

68-6
9
DAS
27
9-89

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST260a

349

m132677

349

ST305

48

m127813

19

m131340

21

m132123

8

SEP 03 2015

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Work Order ID: 136062

136062

Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli-Rappel™ 500 lbs, Fits LH or RH

Start Date: 8/27/2015

Required Date: 9/17/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

1,029.000

8

32

NAS1149D0563.J

DAS

38

9-89

Washer

DAS

6

9-89

27

9-89

Location

Loc Qty

Loc Code

GA

53

m125807

53

ST260a

801

m130799

63

m132035

55

m132256

83

m132677

600

ST269

156

m128257

156

ST271

19

m131026

19

SEP 03 2015



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HA</i>	APPROVED <i>HA</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

20150827

SH 136062

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>D. Shepherd</i>	_____
D. SHEPHERD (DE # 02)	
DATE: _____	05.05.11
CERT. NO.: _____	SH96-90
ISSUE NO.: _____	3

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REFERENCE ONLY**4. WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

5. PARTS LIST

-013	-043	Part No.	Description
X		D205-523-013	HELI-RAPPEL™ INSTALLATION
1	X	D205-523-043	SLIDE BAR ASSEMBLY
	1	D3011-1	RAPPEL SLIDE BAR
	2	33116	STUD FITTING
	2	MS21042L6	NUT (OR MS21042-6)
	2	AN960JD616	WASHER
	2	D3012-1	DECAL
	2	D3012-3	DECAL
	2	D3012-5	DECAL
1		D2224	RAPPEL ANCHOR
2		D2229	DOUBLER
4		AN5-14A	BOLT
8		AN960JD516	WASHER
4		MS21042L5	NUT (OR MS21042-5)